

Work Order ID 52786

October 14, 2009 10:42:17 AM



Page 1

Item ID: D412-742-043

Accept



Setup Start



Revision ID: H

Stop



Item Name: Replacement Float Skidtube

Start Date: 14/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 02/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: *PL*

Date: *09-10-14*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3391	Rev H

0.00

100



DOCUMENT CONTROL

0.00

DC

Memo

Document Control

If D412-742-043 is a W/O on it's own,
Photocopy bluefile and create labels per PPP D412-742-043 CHG004

N/A.

Work Order ID 52786

October 14, 2009 10:42:17 AM



Page 2

Item ID: D412-742-043

Accept



Setup Start



Revision ID: H

Stop



Item Name: Replacement Float Skidtube

Start Date: 14/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 02/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

110



HandFinish

Hand Finishing

HandFinishing

Memo

0.00

0.00

=> 110) 09/12/08 (KL) 5

*****Do not apply LPS, see QC for more info*****

1-Spray inside tube of D3391-021/-023/-025 with LPS-3 as per Dwg D3391

A/R LPS-3 ☐ 10/14

2-Install tubes together and seal them all the way around using Sikaflex 241/291. Ensure tube ends line-up with saddle holes for proper alignment. using 7/16" "T" Pins.



A/R ☐ Sikaflex-241/-291 ☐ 11/12/34 5
Expiry date: ☐ 10/08

3-Install wearplates as per Dwg D3391. Ensure that plastic washers are against wearplate, then topped with the SS washer. Coat bolts with LPS "procyon". Seal all bolts with sikaflex except ones with inserts on inside of tube ,hand tighten only bolts with no sikaflex.

A/R ☐ LPS Procyon ☐ 11/10/25 1
A/R ☐ Sikaflex-241/-291 ☐ 11/12/34 5
Expiry date: ☐ 10/08

4-Remove "T" pins once sikaflex is dry.

5-Coat all exposed hardware with LPS Procyon. Remove any excess off with MEK degreaser.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
09.12.08	110	Acceptable to file saddle holes on inner tube to allow assembly	AK	09/12/08	(X1)	 09.12.08 09/12/08	 09/12/08

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 52786

October 14, 2009 10:42:17 AM



Page 3

Item ID: D412-742-043

Accept



Setup Start



Revision ID: H

Stop



Item Name: Replacement Float Skidtube

Start Date: 14/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 02/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

>> 80812108

Memo

0.00



f

130



Packaging

Packaging

Packaging

0.00

Memo

0.00

Identify and pack for shipping as per PPP D412-742-043

Location: _____

PPP Rev: _____ PPP 54410

09/14/17 (11)

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

09.12.16

09.12.15

Picklist Print

Page 1

October 14, 2009 10:42:25 AM

Work Order ID: 52786

Parent Item: D412-742-043RevH

Parent Item Name: Replacement Float Skidtube


Comments:

Start Date: 14/10/2009

Required Date: 02/11/2009


Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN3C4A 		Purchased	No			110	Each	2,216.000	24.0000			
BOLT												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse	M 113359	
ST	2216	
112082	14	
112314	40	
112720	162	
112724	500	
112794	1000	
112829	500	

x24 H 09/12/02

AN3C6A 		Purchased	No			110	Each	948.0000	12.0000			
BOLT												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	948	
(111982)	948	

x12 H 09/12/02

Picklist Print

October 14, 2009 10:42:25 AM

Work Order ID: 52786

Parent Item: D412-742-043RevH

Parent Item Name: Replacement Float Skidtube


Comments:

Start Date: 14/10/2009

Required Date: 02/11/2009


Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN3C7A  BOLT		Purchased	No			110	Each	289.0000	8.0000			


<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse	M113149	
ST	289	
105906	21	
107376	268	

x8 M 09/12/08

AN960C10L  washer		Purchased	No			110	Each	4,772.000	44.0000			
--	--	-----------	----	--	--	-----	------	-----------	---------	--	--	--

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
OFFSHORE	M112933	
FG	100	
103585	100	
Main Warehouse		
ST	4672	
112116	1009	
112612	3663	

x44 M 09/12/08

D3391-021RevH  Fwd Tube Assembly		Manufactured	No			110	Each	0.0000	1.0000			
---	--	--------------	----	--	--	-----	------	--------	--------	--	--	--

X1

B52362 M 09/12/08

gubed on
53937

Picklist Print

October 14, 2009 10:42:25 AM

Work Order ID: 52786

Parent Item: D412-742-043RevH

Parent Item Name: Replacement Float Skidtube

Comments:

Start Date: 14/10/2009

Required Date: 02/11/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3391-023RevH

Manufactured

No

110

Each

1.0000

1.0000



x\

B53937 09/12/08

Mid Tube Assembly

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

1

40522

1

D3391-025RevH

Manufactured

No

110

Each

2.0000

1.0000



x\

B52797 09/12/08

Aft Tube Assembly

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

2

39129

1

48122

1

Picklist Print

October 14, 2009 10:42:25 AM

Work Order ID: 52786



Parent Item: D412-742-043RevH



Parent Item Name: Replacement Float Skidtube



Start Date: 14/10/2009

Required Date: 02/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3564-1RevD  Wearshoe		Manufactured	No			110	Each	29.0000	1.0000 			

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
OFFSHORE		
FG	2	
33798	2	
Main Warehouse		
ST	27	
47531	1	
48163	4	
50270	1	
51676	21	

xl 09/12/08

Picklist Print

October 14, 2009 10:42:25 AM

Work Order ID: 52786

Parent Item: D412-742-043RevH

Parent Item Name: Replacement Float Skidtube

Comments:

Start Date: 14/10/2009

Required Date: 02/11/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3564-3RevD		Manufactured	No			110	Each	20.0000	1.0000			
Wearshoe												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
OFFSHORE		
FG	2	
33764	2	
Main Warehouse		
FP	11	
50113	11	
Main Warehouse		
ST	7	
46445	1	
46652	3	
50364	3	

x1 41 09/12/08

Picklist Print

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Parent Item: D412-742-043RevH



Parent Item Name: Replacement Float Skidtube


Start Date: 14/10/2009

Required Date: 02/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3564-5RevD 		Manufactured	No			110	Each	30.0000	1.0000			
Wearshoe												

Warehouse
Location

Loc Qty

Loc Code

OFFSHORE

B53805

x1 41 09/12/08

FG

2

34806

2

Main Warehouse

FP19

26

51655

15

51925

11

Main Warehouse

ST

2

45824

1

47433

1

Picklist Print

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October 14, 2009 10:42:25 AM

Work Order ID: 52786



Parent Item: D412-742-043RevH



Parent Item Name: Replacement Float Skidtube

Start Date: 14/10/2009

Required Date: 02/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3566-1RevC		Manufactured	No			110	Each	11.0000	2.0000			

Gasket

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse	B53790	
FP	3	
51612	3	
Main Warehouse		
ST	8	
46349	1	
51218	1	
51259	3	
52313	3	

VZ J1 09/12/08

Picklist Print

October 14, 2009 10:42:25 AM

Work Order ID: 52786



Parent Item: D412-742-043RevH



Parent Item Name: Replacement Float Skidtube

Start Date: 14/10/2009

Required Date: 02/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3566-5RevC		Manufactured	No			110	Each	25.0000	1.0000			



Gasket

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

853804

Y1 Y1 09/12/08

FP

12

51929

12

Main Warehouse

FP19

9

51669

9

Main Warehouse

ST

4

36113

1

46186

1

47318

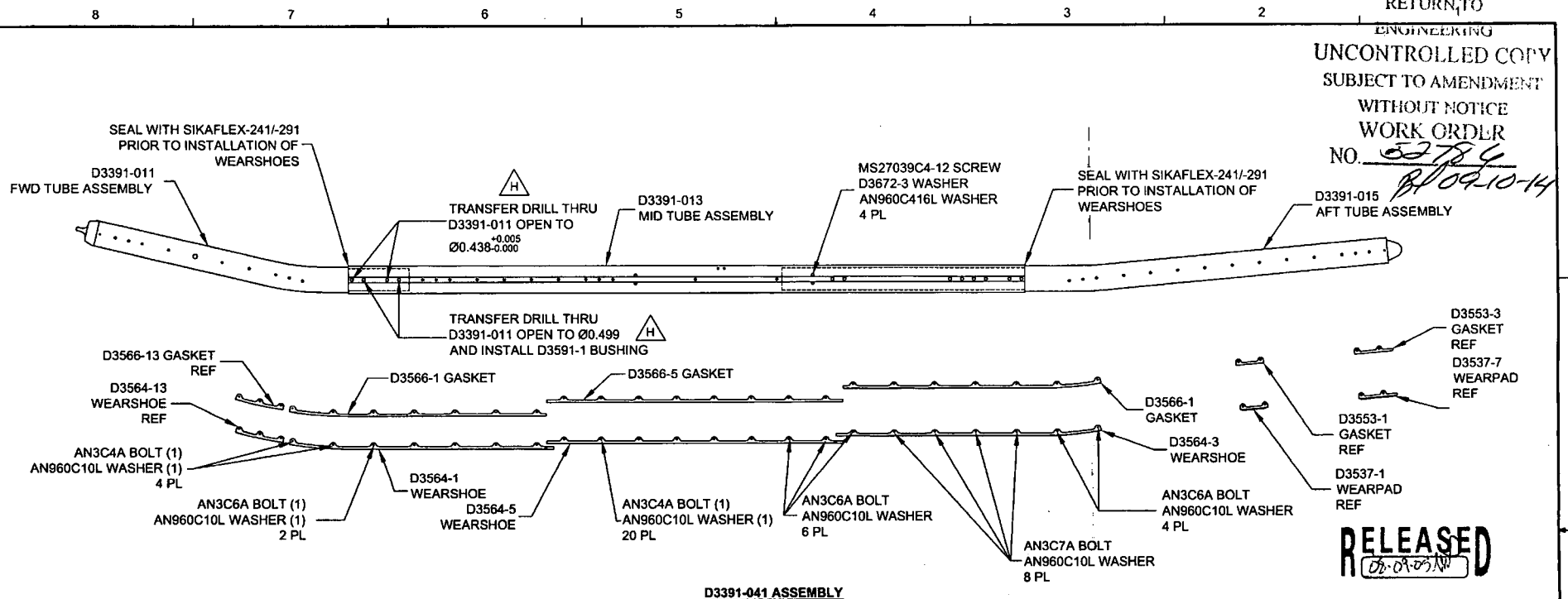
1

51260

1

SHOP COPY
RETURN TO

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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 52789
8/09-10-14



D3391-041 ASSEMBLY

D3391-041 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

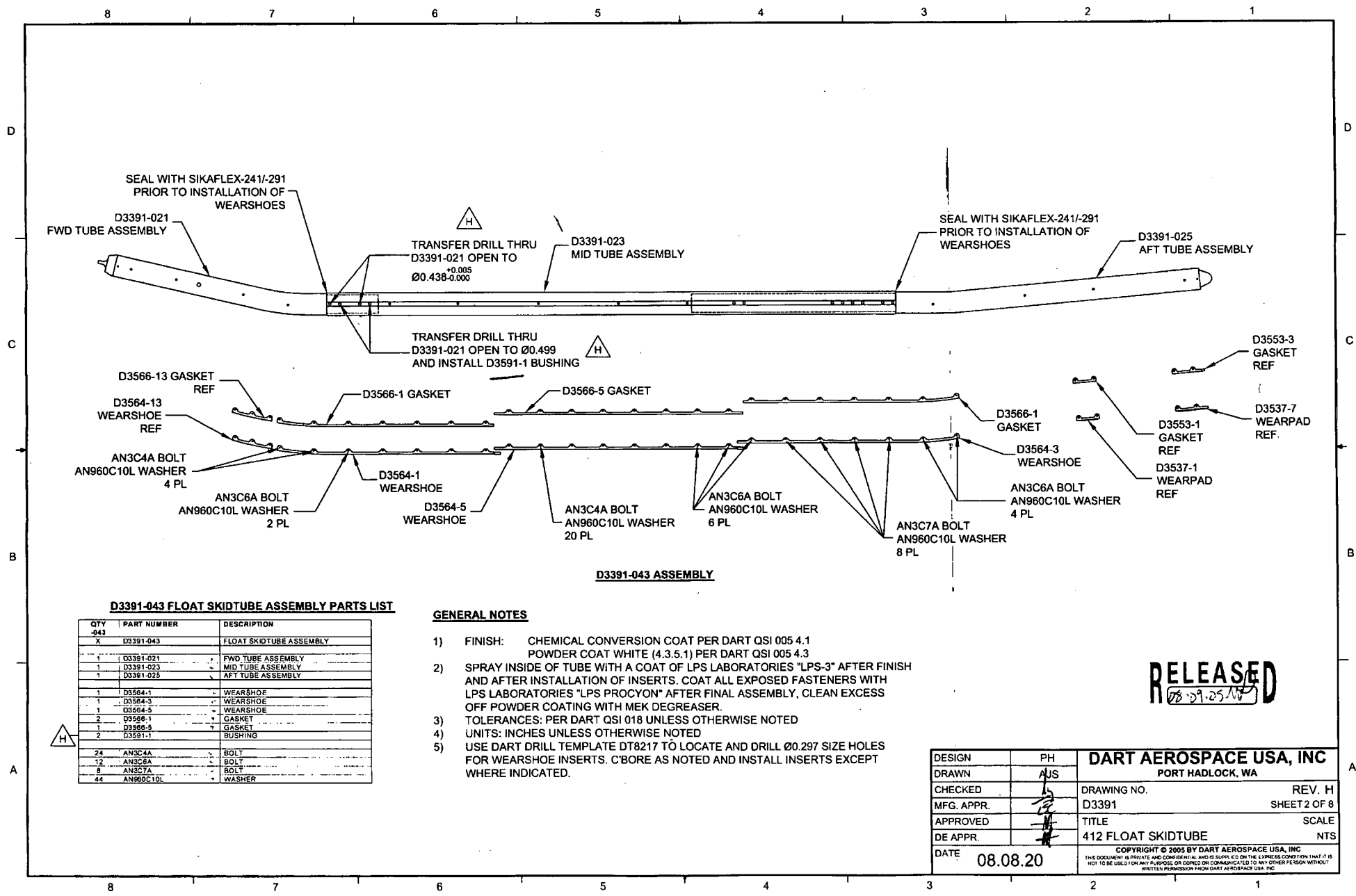
QTY	PART NUMBER	DESCRIPTION
X	D3391-041	FLOAT SKIDTUBE ASSEMBLY
1	D3391-011	FWD TUBE ASSEMBLY
1	D3391-013	MID TUBE ASSEMBLY
1	D3391-015	AFT TUBE ASSEMBLY
1	D3564-1	WEARSHOE
1	D3564-3	WEARSHOE
1	D3564-5	WEARSHOE
2	D3566-1	GASKET
1	D3566-5	GASKET
2	D3591-1	BUSHING
4	D3672-3	WASHER
24	AN3C4A	BOLT
12	AN3C6A	BOLT
6	AN3C7A	BOLT
44	AN960C10L	WASHER
4	MS27038C4-12	SCREW
4	AN960C416L	WASHER

GENERAL NOTES

- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH
AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH
LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS
OFF POWDER COATING WITH MEK DEGREASER.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 SIZE HOLES
FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT
WHERE INDICATED.

H	DRAWING UPDATED TO CURRENT STANDARDS. SHT 1 PL ADDED D3591-1 BUSHING. ZN C6 Ø0.438 DIM WAS 4 PL. ADDED Ø0.499 DIM AND D3591-1 BUSHING. SHT 2 PL ADDED D3591-1 BUSHING. ZN C6 Ø0.438 DIM WAS 4 PL. ADDED Ø0.499 DIM AND D3591-1 BUSHING. (FOR FURTHER INFO SEE DSI 9364 & NCR 08-074)	AJS	08.08.20
G	REPLACE NAS INSERTS W/ AELS INSERTS SWITCH TO D3670-XXXX SPACERS FOR INSTALLING FLOAT BAGS, DWG REORGANIZED FOR CLARITY	DC	07.07.31
F	ADD SS WEARSHOE, GASKET REMOVE FWD SADDLE HOLE -011/-021	PH	07.01.18
E	CHANGE TOLERANCE, EASE MANUFACTURE	PH	06.04.25
D	UPDATE TOLERANCE, CHANGE HOLE SIZE	PH	06.01.23
C	LENGTHEN AFT EXTENSION	PH	05.09.27
B	DRAWING UPDATES	PH	05.06.10
A	NEW ISSUE	PH	05.02.07
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D3391	SHEET 1 OF 8
APPROVED		TITLE	SCALE
DE APPR.		412 FLOAT SKIDTUBE	NTS
DATE	08.08.20	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC	

W/0 52784







D3391-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

QTY	PART NUMBER	DESCRIPTION
-043		
X	D3391-043	FLOAT SKIDTUBE ASSEMBLY
1	D3391-021	FWD TUBE ASSEMBLY
1	D3391-023	MID TUBE ASSEMBLY
1	D3391-025	AFT TUBE ASSEMBLY
1	D3564-1	WEARSHOE
1	D3564-3	WEARSHOE
1	D3564-5	WEARSHOE
2	D3566-1	GASKET
1	D3566-3	GASKET
2	D3566-5	BUSHING
24	AN3C4A	BOLT
12	AN3C6A	BOLT
8	AN3C7A	BOLT
44	AN960C10L	WASHER

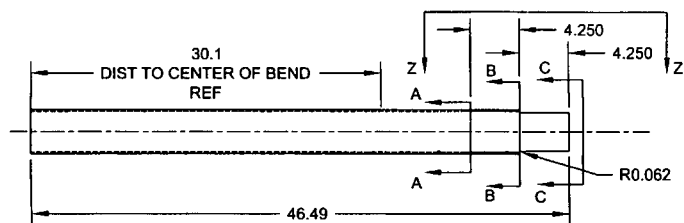
GENERAL NOTES

- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
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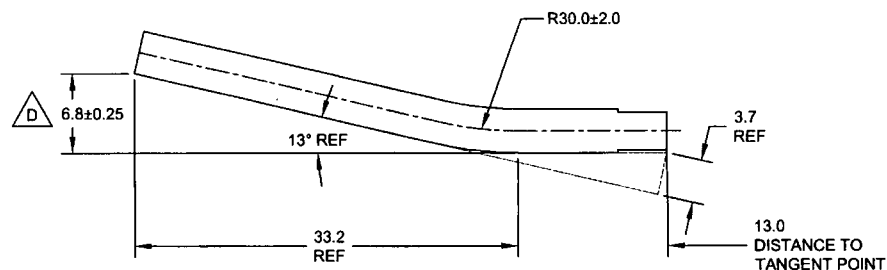
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08-09-25-10

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D3391	SHEET 2 OF 8
APPROVED		TITLE	SCALE
DE APPR.		412 FLOAT SKIDTUBE	NTS
DATE	08.08.20	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC</small>	

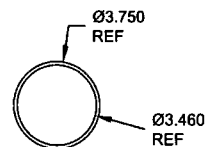
W/O 52784



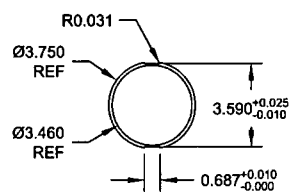
D3391-1 CUTTING DETAIL
(MAKE FROM D6013-047 SKIDTUBE MATERIAL)



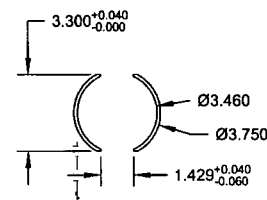
D3391-011/-021 BENDING DETAIL
(MAKE FROM D3391-1)



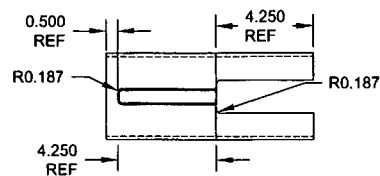
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SCALE 2X



SECTION B-B
SCALE 2X



SECTION C-C
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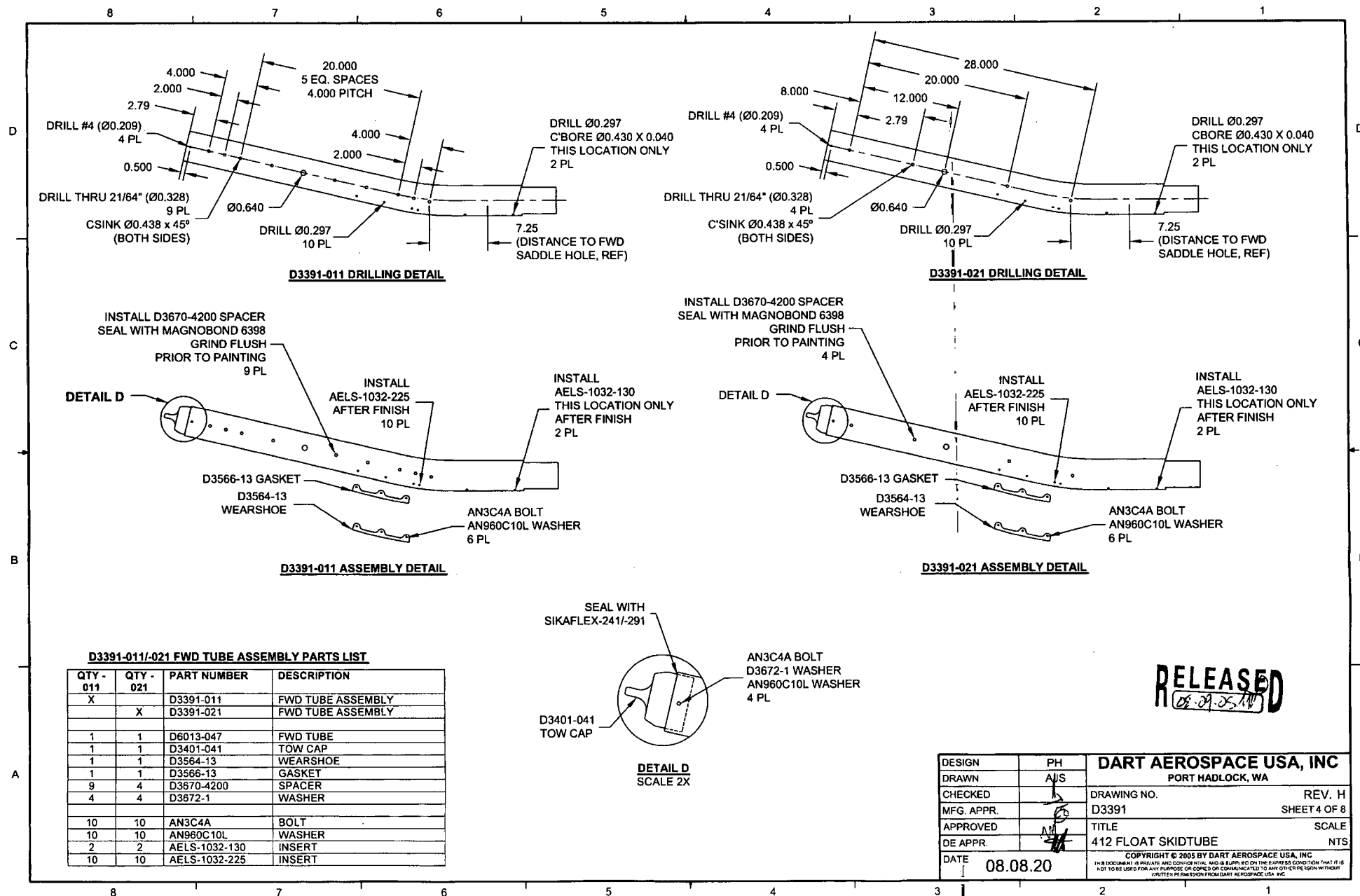


VIEW Z-Z
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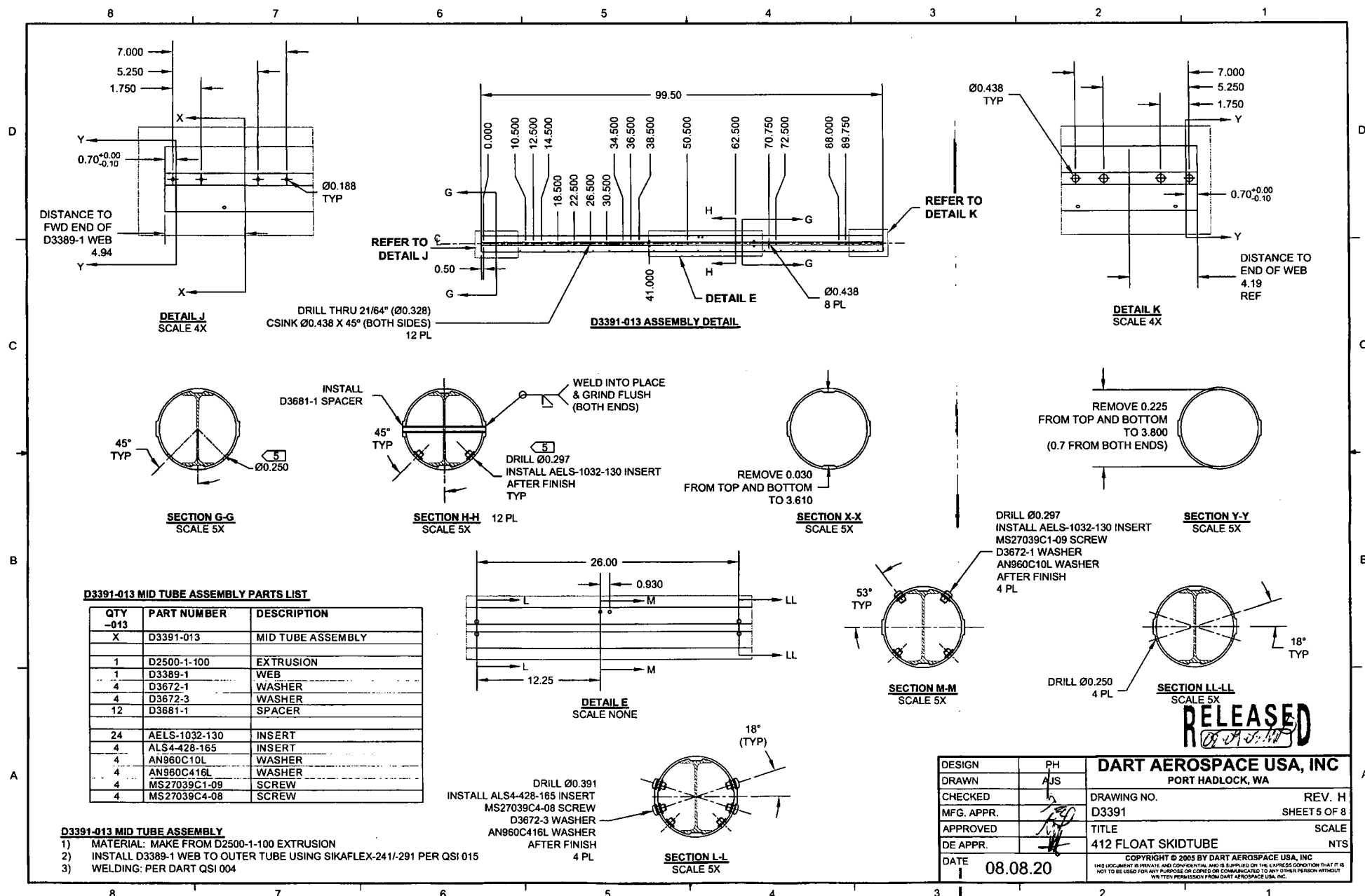
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CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D3391	SHEET 3 OF 8
APPROVED		TITLE	SCALE
DE APPR.		412 FLOAT SKIDTUBE	NTS
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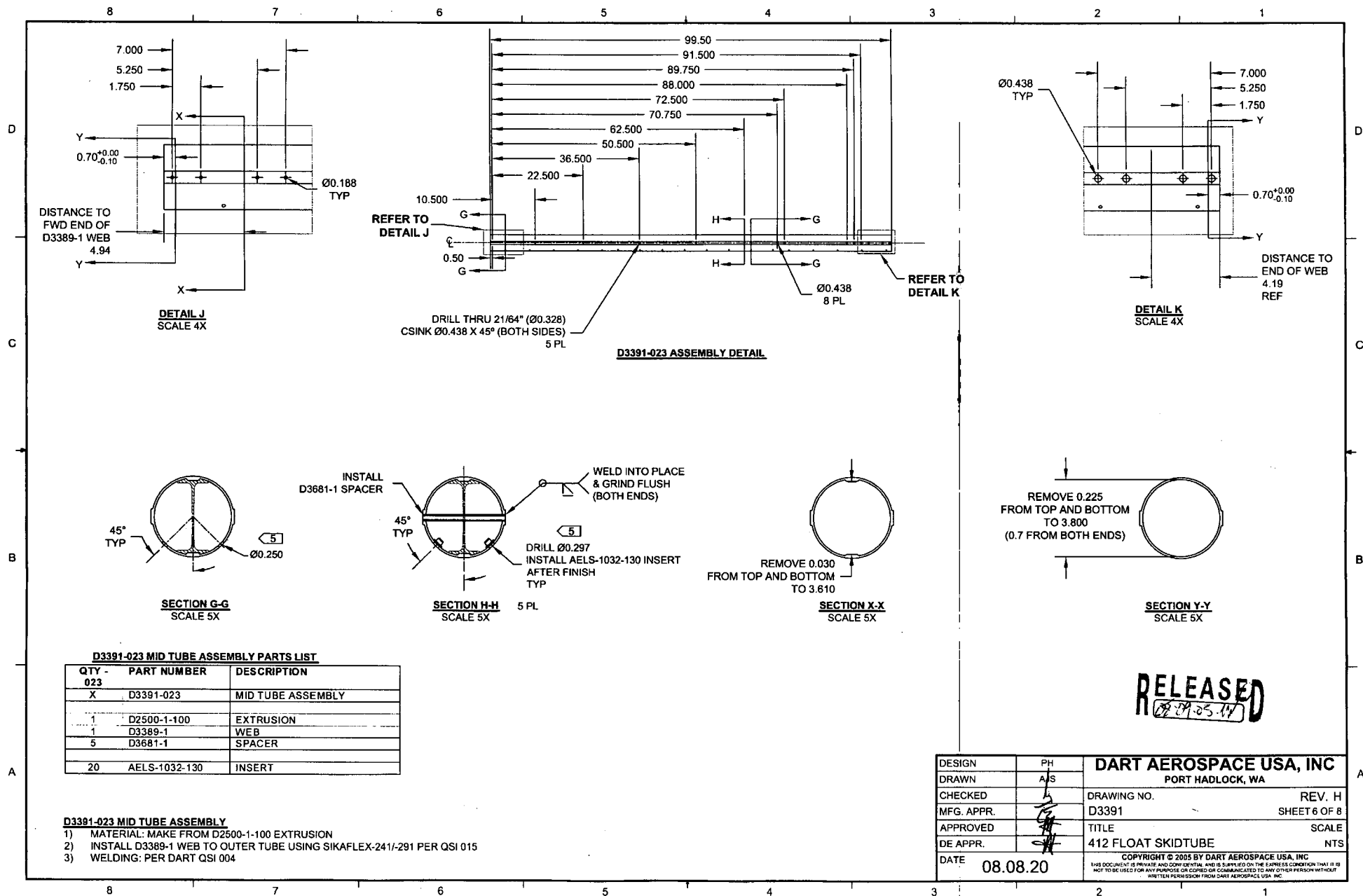
W/0 52789



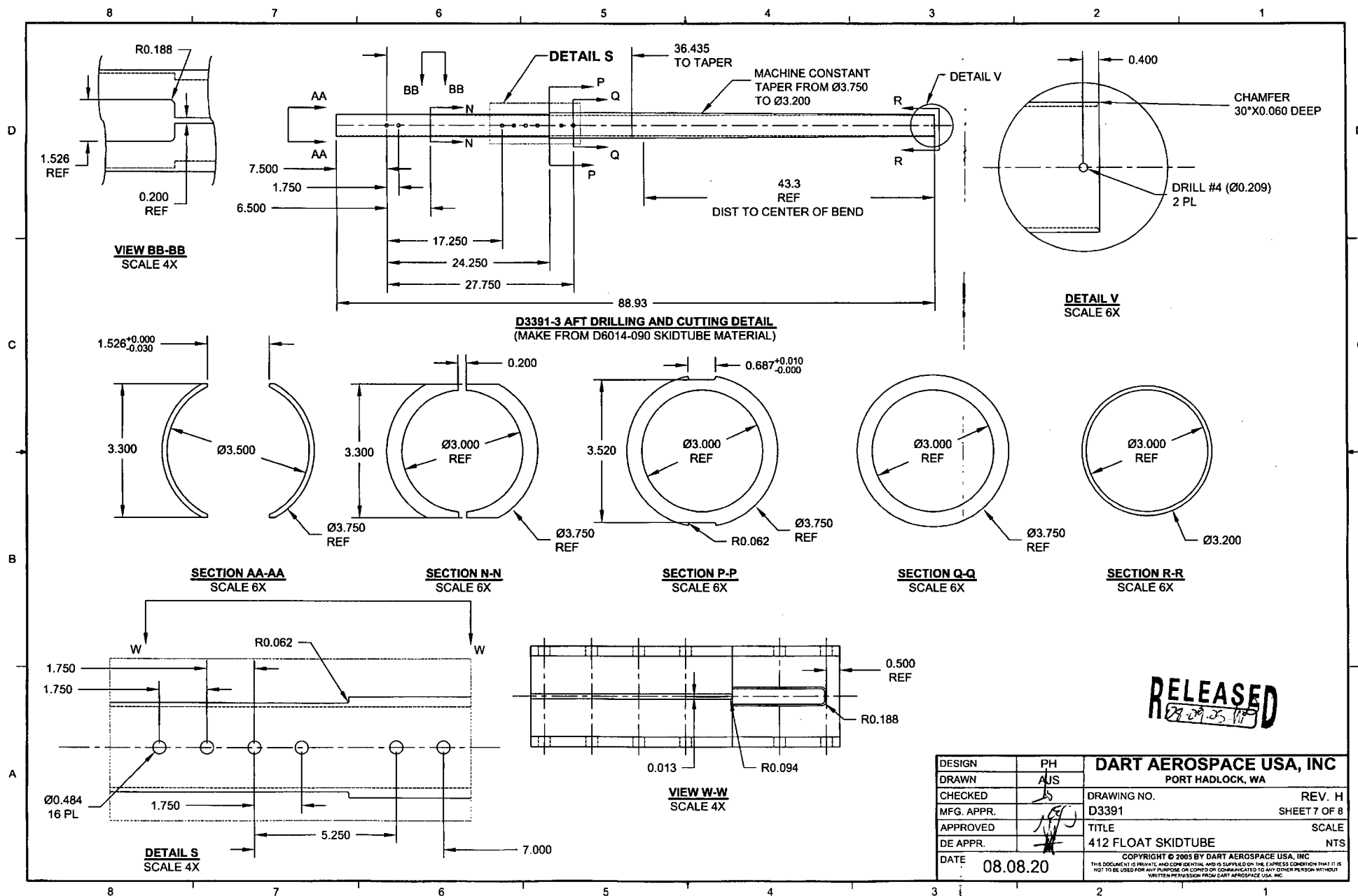
W/O 52784




w/o 52784



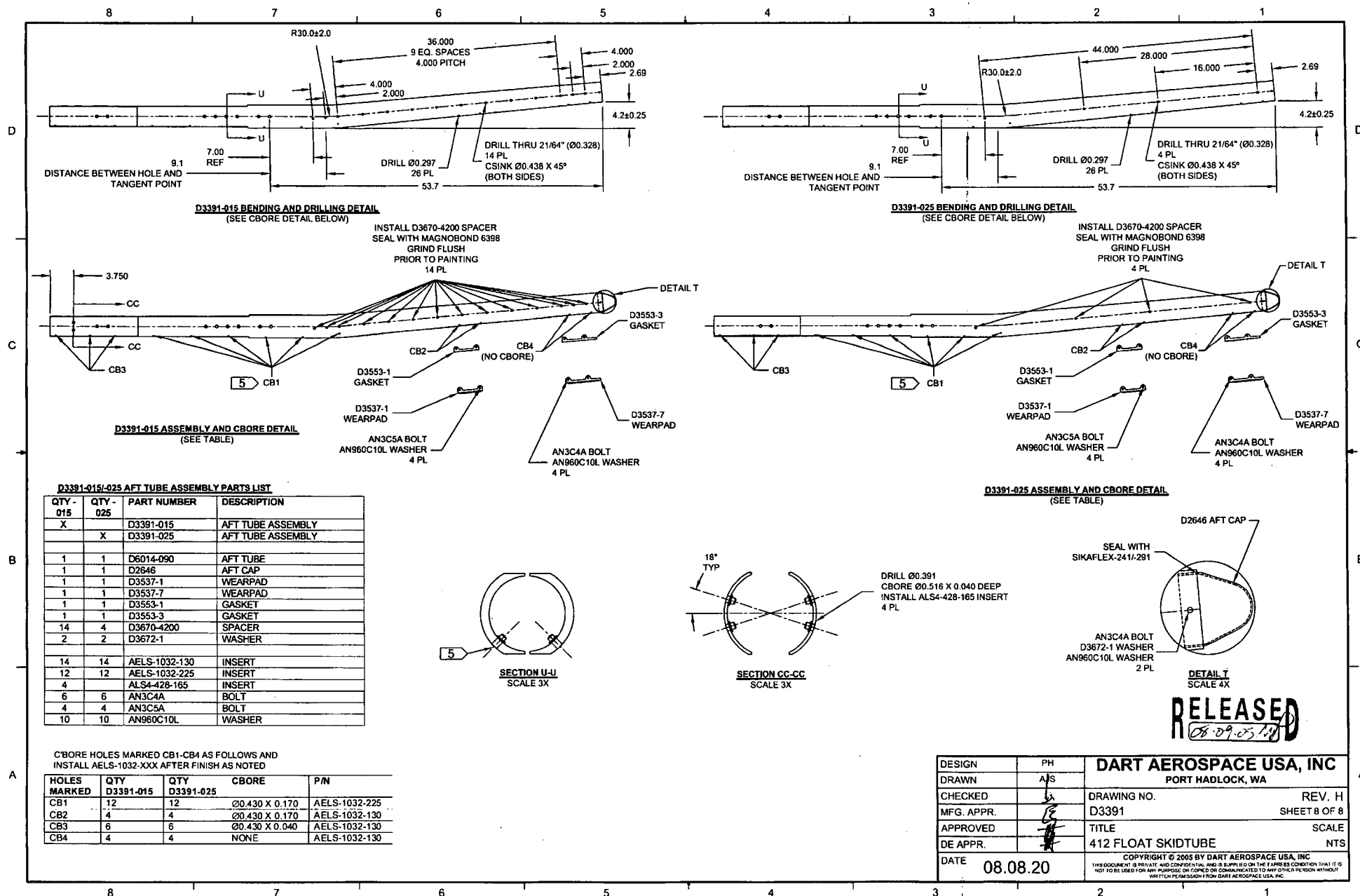
W/O 52784



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08-08-20

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D3391	SHEET 7 OF 8
APPROVED		TITLE	SCALE
DE APPR.		412 FLOAT SKIDTUBE	NTS
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W/0 52786



5.2 D412-742-013 (APICAL TRI-BAG) Float Skidtube Installation Parts List

Item	Qty -013	Qty -043	Part Number	Description
	X		D412-742-013	FLOAT SKIDTUBE INSTALLATION
	1	X	D412-742-043	FLOAT SKIDTUBE
		1	D3391-043	412 FLOAT SKIDTUBE
1		*24	*AN3C4A	*BOLT
3		*12	*AN3C6A	*BOLT
4		*8	*AN3C7A	*BOLT
5		*44	*AN960C10L	*WASHER
21A		*1	*D3564-1	*WEARSHOE (REPLACES D3460-1)
21B		*1	*D3566-1	*GASKET
22A		*1	*D3564-3	*WEARSHOE (REPLACES D3460-3)
22B		*1	*D3566-1	*GASKET
23A		*1	*D3564-5	*WEARSHOE (REPLACES D2577-5)
23B		*1	*D3566-5	*GASKET
10		*1	*D3391-021	*412 FORWARD TUBE
11		**1	**D3401-041	**TOW CAP
12A		**10	**AELS-1032-225	**INSERT (REPLACES NAS1330S3KB166)
12B		**2	**AELS-1032-130	**INSERT (REPLACES NAS1330S3KB166)
13		**10	**AN3C4A	**BOLT
14A		**4	**D3672-1	**WASHER (REPLACES NAS1515H3L)
14B		**10	**AN960C10L	**WASHER
24A		**1	**D3564-13	**WEARSHOE
24B		**1	**D3566-13	**GASKET
20		*1	*D3391-023	*412 MID TUBE
28		**20	**AELS-1032-130	**INSERT (REPLACES NAS1330S3KB116)
30		*1	*D3391-025	*412 AFT TUBE
25A		**1	*D3537-1	**WEARPAD
25B		**1	*D3553-1	**GASKET
26A		**1	*D3537-7	**WEARPAD
26B		**1	*D3553-3	**GASKET
31		**1	**D2646	**AFT CAP
32		**14	**AELS-1032-130	**INSERT
36		**12	**AELS-1032-225	**INSERT (REPLACES NAS1330S3KB366)
37A		**6	**AN3C4A	**BOLT
37B		**4	**AN3C5A	**BOLT
38A		**2	**D3672-1	**WASHER (REPLACES NAS1515H3L)
38B		**10	**AN960C10L	**WASHER

(CONTINUED ON PAGE 19)

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